

Work Order ID 82127

82127

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March-23-12 10:45:42 AM

Item ID: D2654-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 23/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/04/2012 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2654 | F |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 100 | Skidtubes | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends | | | | | | | | |
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

4 / CF 12-4-19

DP 12-4-19

4 / CF 12-4-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


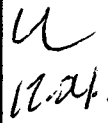

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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1120420

| W/O: 82127 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|---|---------|-----|---|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 12-4-19 | 130 | Should read QC7 |  | 12-4-19 | |  12-21-20 |  12/4/20 |
| | | | | | | | |

Part No: D2654-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-23-12 10:45:46 AM

Page 1

Work Order ID: 82127

82127

Parent Item: D2654-5

D2654-5

Parent Item Name: Web

Start Date: 23/03/2012

Required Date: 06/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-7-140 *D2600-7-140* EXT. "I BEAM" THICK | | Manufactured | No | | | 100 | Each | 151.0000 | 1 | 4 | | | |
| | | | | | | | | | ** | (4) | CF 12-4-19 | | |

Location

Loc Qty

Loc Code

LG

151

41591

3

12279

148

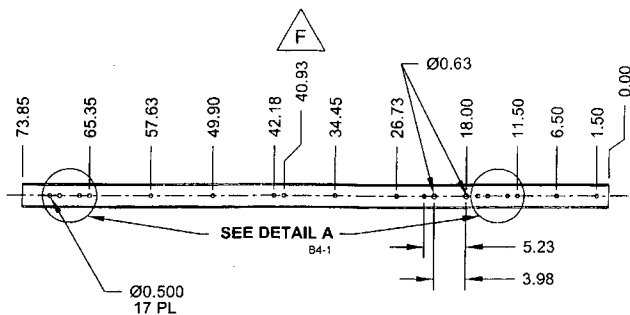
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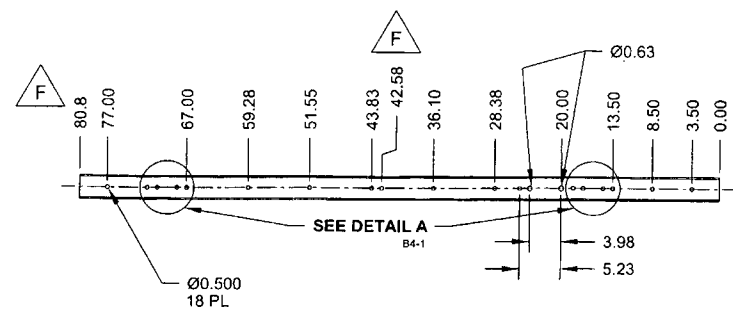
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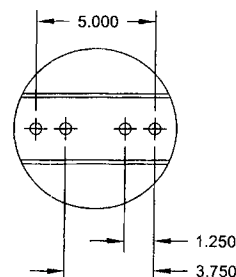
D2654-1 WEB



D2654-3 WEB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82127 *MLJ*
12/03/23



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

RELEASED
2011-09-12
W

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

| REV. | DESCRIPTION | BY | DATE |
|------------|--|--|--------------|
| F | ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2 | SC | 11.05.05 |
| E | CHANGE LENGTHS, REFORMAT | CP | 04.05.26 |
| D | GHW HOLES CHANGED TO Ø0.63 | CP | 98.01.15 |
| C | CHANGED HOLE PATTERN | CP | 97.10.29 |
| B | ALTER HOLE PATTERN, 0.500 WAS 0.438 | CP | 97.06.26 |
| A | NEW ISSUE | CP | 97.03.25 |
| DESIGN | CP | DART AEROSPACE USA, INC PORT HADLOCK, WA | |
| DRAWN | SC | | |
| CHECKED | <i>JP</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>JP</i> | D2654 | SHEET 1 OF 2 |
| APPROVED | <i>JP</i> | TITLE | SCALE |
| DE APPR. | <i>JP</i> | WEB | NTS |
| DATE | 11.05.05 | <small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

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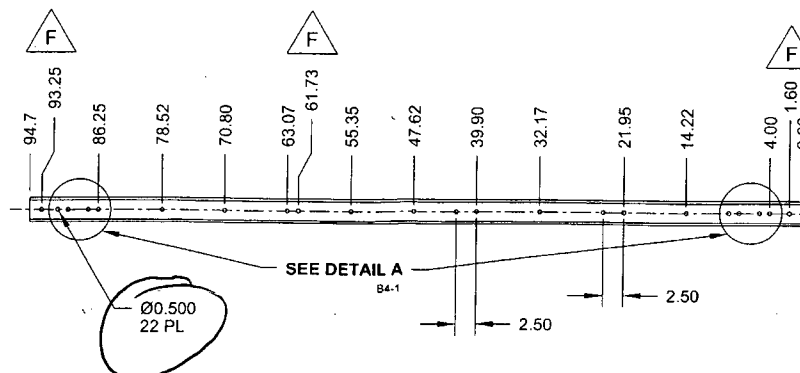
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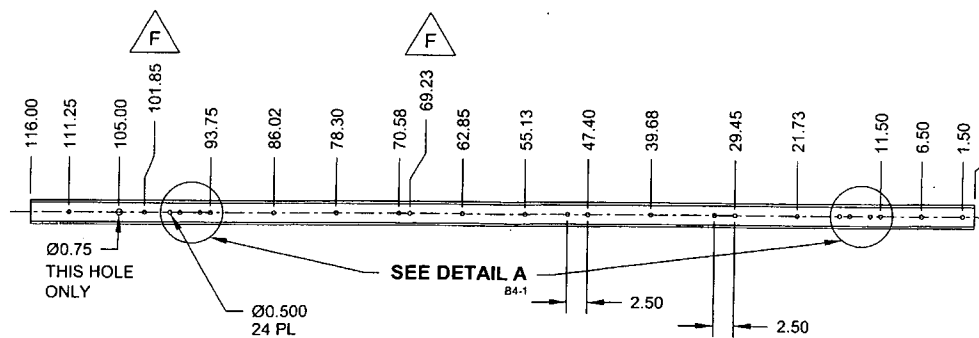
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NOTE: Date & initial all entries

82127



D2654-5 WEB



D2654-7 WEB

RELEASED
2011-09-12

| | | | |
|------------|----------|--|--------------|
| DESIGN | CP | DART AEROSPACE USA, INC | |
| DRAWN | SC | PORT HADLOCK, WA | |
| CHECKED | JP | DRAWING NO. | REV. F |
| MFG. APPR. | JP | D2654 | SHEET 2 OF 2 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | WEB | NTS |
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